

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000414**Date Inspected:** 03-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gu Xin Zhai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** MOCK UP**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested at the ZPMC lab to randomly observe macro etching of fillet weld soundness specimens A, B, C and D of Caltrans Lot Number B75-057-07 for PQR HP2007257-1. ZPMC CWI Huang way rejected samples A and C due to lack of fusion. The following photograph provides additional detail.

Elevation 77:

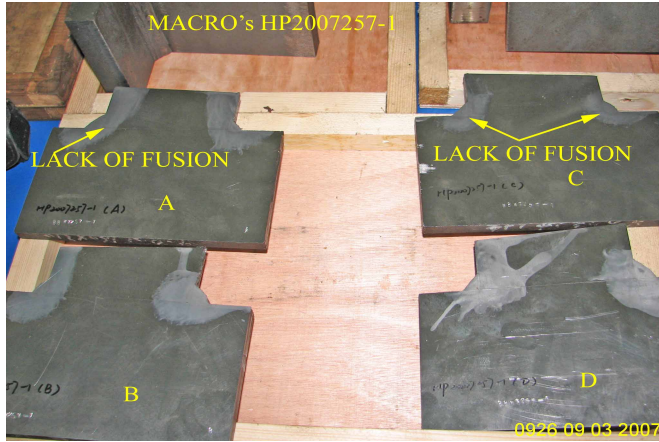
Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding being performed for the fabrication of the Mock Up at elevation 77. The QA Inspector randomly observed a ZPMC helper grinding the root passes of weld joints MUSA-MA4-9 and MUSA-MA4-10 of skin plate C in preparation for magnetic particle (MT) examination. The QA Inspector also observed ZPMC NDT Technician Cai Xin Xin performing a check on the MT yoke with a calibrated 10 pound block and a check of the MT yoke with a pie gage. The QA Inspector left the Mock Up area prior to any MT being performed.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

ZPMC CWI Huang Wei informed the QA Inspector that a new fillet weld soundness test would be performed in a couple of days.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Franco,Charlie

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer